

Work Order ID 77677

77677

Page 1

December-16-11 11:10:15 AM

Item ID: D3929-042

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Gusset Assembly

Start Date: 16/12/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/12/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: 1A

Prog Rev: 1A

2-Deburr if necessary

B11-12-28

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-12-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3929-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gusset Assembly
 Start Date: 16/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch: <u>M115778</u>								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

Sul12/28

(FE)

12.01.19 8x

8 φ
12.01.20

W/O:		WORK ORDER CHANGES					
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Page 3

December-16-11 11:10:15 AM

Item ID: D3929-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gusset Assembly
 Start Date: 16/12/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(x8)			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Bodert Cell Memo	0.00 0.00							12-01-19 8x
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/11/23 12-01-23 (8)

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NOTE: Date & initial all entries

Picklist Print

December-16-11 11:10:19 AM

Page 1

Work Order ID: 77677

77677

Parent Item: D3929-042

D3929-042

Parent Item Name: Gusset Assembly

Start Date: 16/12/2011

Required Date: 22/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

61.9000

0.45

2.842105

3.5

M304S11GA

304/316 0.125 Sheet

**

B11-12-28

Location

Loc Qty

Loc Code

MAT020

61.9

119006

32.5

119048

29.4

119048

(8)

D3907-1

Manufactured

No

130

Each

37.0000

2

12

D3907-1

Bushing

**

12.01.19

Location

Loc Qty

Loc Code

WA005

37

65920

4

70673

1

73008

32

Kex

W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REWORK
WITHOUT NOTICE
WORK ORDER NO. 77677 M.L.S
11/12/16

D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
3/10/12/16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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77677

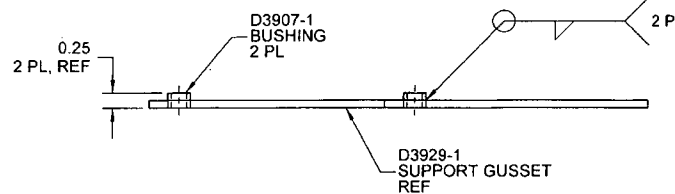
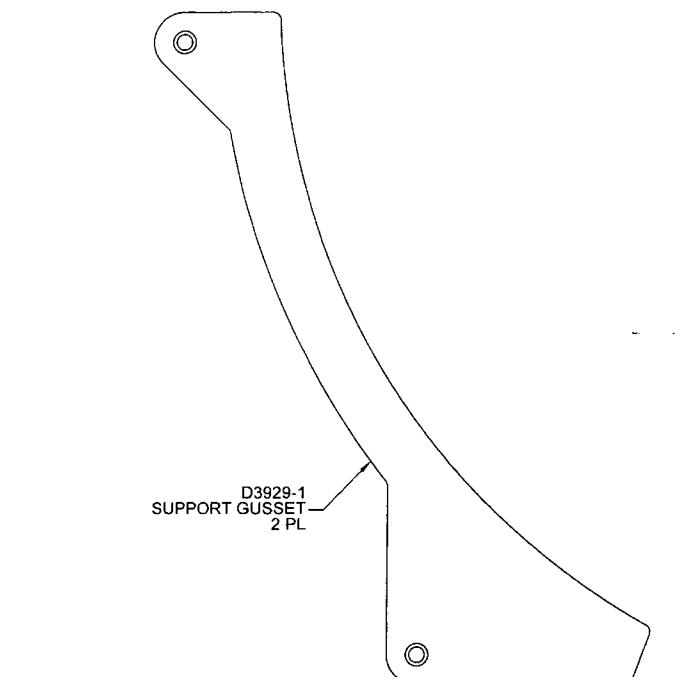
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D

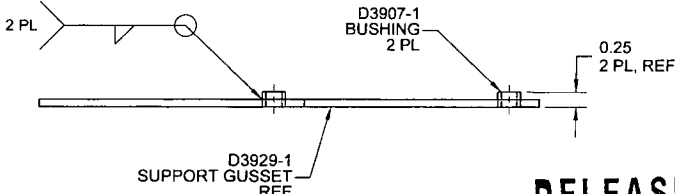
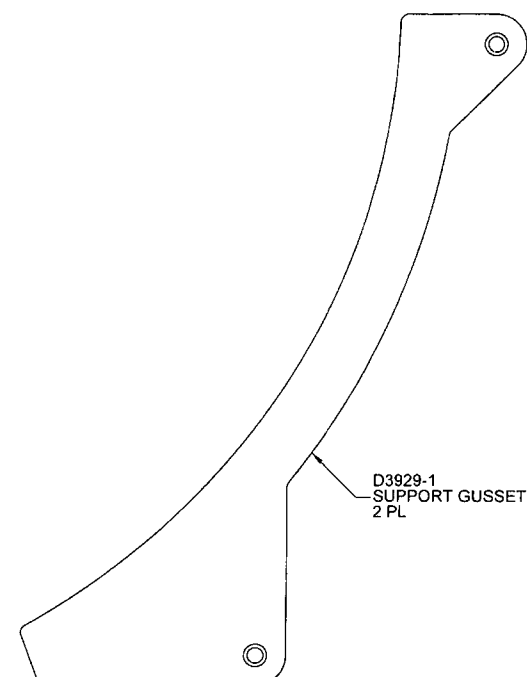
C

B

A



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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8 7 6 5 4 3 2 1

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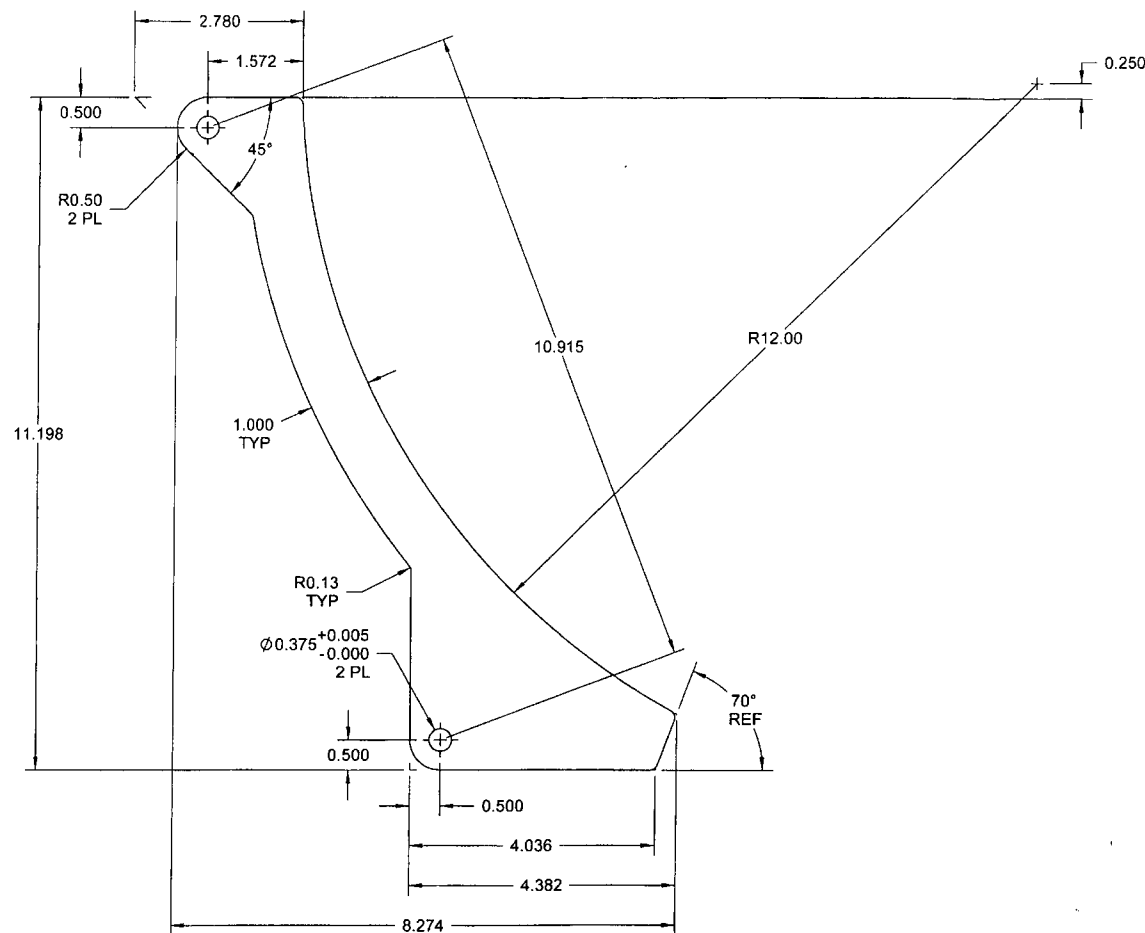
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77677



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
09/04/22 JWD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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